

Work Order ID 108543

October-21-13 8:20:14 AM

\*108543\*

Page 1

Item ID: D2966-1-BENT

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube Assembly 105

Start Date: 10/21/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/28/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJDate: 13-10-21 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2966

Rev A

120

0.00

\*120\*

BENDING MACHINE - SKIDTUBES

0.00

CNC Bend 1

Memo

CNC Delta 100 Bender

1-Bend tube as per program BO105 on CNC Bender and Dwg D2966. Bend folio #1 use bending aid DT9631

2-Cut Fwd end of the tube using DT8185-1

> mm 13/10/29

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

Quality Control

DP 13-10-29

300

Identify as per dwg & Stock Location: 46

0.00

\*300\*

Packaging

Memo

Packaging

Packaging

0.00

DP 13-10-29

6

**Work Order ID 108543**

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**\*108543\***

Page 2

Item ID: D2966-1-BENT

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Assembly 105

Stop **\*NS2\***

Start Date: 10/21/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 10/28/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

310

QC21 - Final Inspection - Work Order Release

0.00

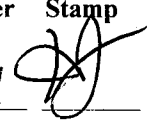
**\*310\***

QC

Memo

0.00

Quality Control

13/10/31   
MF  
13-10-30

# Picklist Print

October-21-13 8:20:18 AM

Page 1

Work Order ID: 108543

\*108543\*

Parent Item: D2966-1-BENT

\*D2966-1-BENT\*

Parent Item Name: Skidtube Assembly 105

Start Date: 10/21/13

Required Date: 10/28/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 10.09.17 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2962-125

Manufactured No

Each

0.0000

6

\*D2962-125\*

Outer Tube Extrusion

\*\*

B59934

DD 13-10-29

-150

13.10.29.



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED  
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

1085 Y3 MLS  
13-10-21



#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.4) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART  
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



# 01.01.29  
iP 01.01.30

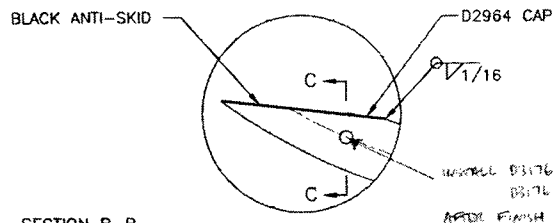
AZ	02.10.30	ADD D3176-1/-3	# CP
AI	01.01.29	CHANGE COLOR TO BLACK SANDTEX	# CP

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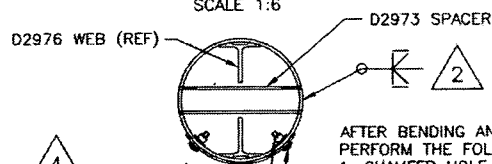
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108543

DETAIL A  
SCALE 1:3



SECTION B-B  
SCALE 1:6

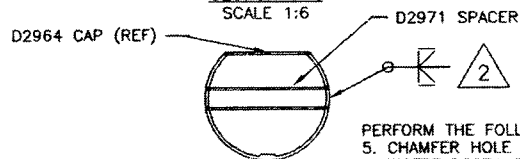


AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.750$  HOLES ONLY:  
1. CHAMFER HOLE  $0.030 \times 45^\circ$   
2. INSERT D2973 SPACER (7 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. PASS  $\phi 0.630$  DRILL TO REMOVE SPILL OVER

ALS7-1032-130 INSERT (34 PLACES)

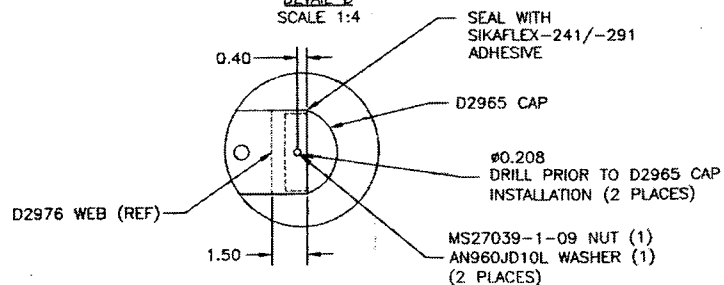
MS27039-1-08 SCREW (1)  
AN960JD10L WASHER (1)  
(26 PLACES)

SECTION C-C  
SCALE 1:6

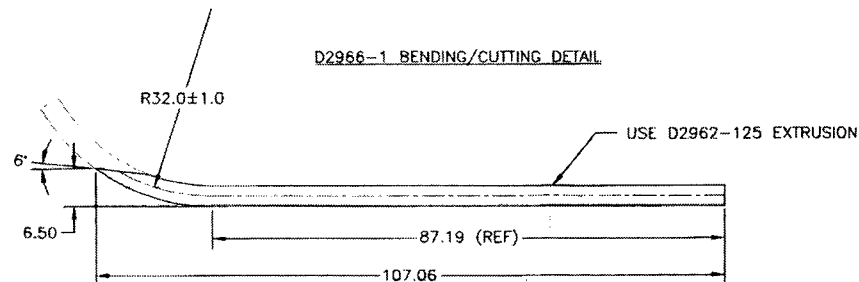


PERFORM THE FOLLOWING FOR  $\phi 0.625$  HOLES ONLY:  
5. CHAMFER HOLE  $0.030 \times 45^\circ$   
6. INSERT D2971 SPACER  
7. WELD INTO PLACE AND GRIND FLUSH  
8. PASS  $\phi 0.484$  DRILL TO REMOVE SPILL OVER

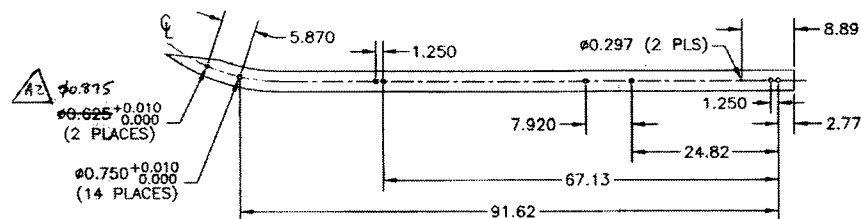
DETAIL D  
SCALE 1:4



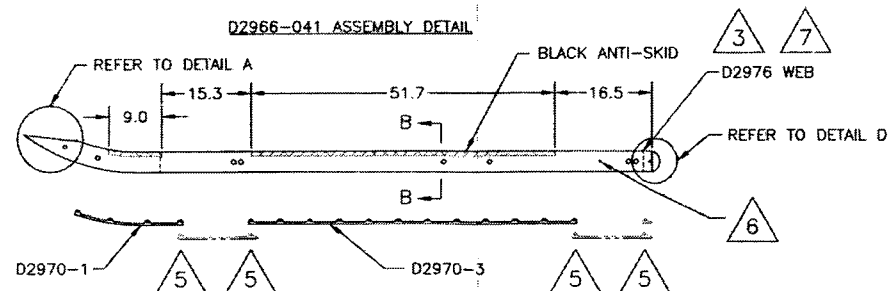
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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DATE 00.03.08		TITLE B0 105 SKIDTUBE ASSEMBLY		SCALE 1:20	